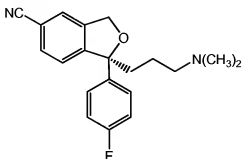


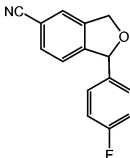
Claims of the Application:

1. (Original) A process for preparing escitalopram having the structure:



comprising the steps of:

- (a) reacting 5-cyano-1-(4-fluorophenyl)-1,3-dihydroisobenzofuran having the structure:



with 3-chloropropylamine in the presence of a base;

- (b) reacting a product from (a) with an enantiomerically pure acid;  
(c) hydrolyzing a product from (b) using a base;  
(d) methylating a product recovered from (c); and  
(e) recovering escitalopram.

2. (Original) The process of claim 1, wherein an enantiomerically pure acid is a di-benzoyltartaric acid, a di-p-toluoyl tartaric acid, an o-nitrobenzoyl tartaric acid, lactic acid, bisnaphthylphosphoric acid, 10-camphorsulfonic acid, 8-camphorsulfonic acid, malic acid, N-acetyl glutamic acid, or mandelic acid.

3. (Original) The process of claim 1, wherein an enantiomerically pure acid is (-)-di-p-toluoyl tartaric acid.

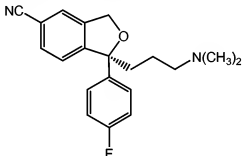
4. (Original) The process of claim 1, wherein a product from (c) is methylated using methyl iodide, dimethyl sulfate or a mixture of formic acid and formaldehyde.

5. (Original) The process of claim 1, wherein a product from (c) is methylated using a mixture of formic acid and formaldehyde.

6. (Original) The process of claim 5, wherein recovered escitalopram contains less than about 0.2 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

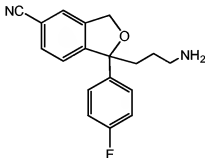
7. (Original) The process of claim 5, wherein recovered escitalopram contains less than about 0.01 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

8. (Original) A process for preparing escitalopram having the structure:



comprising the steps of:

(a) reacting 5-cyano-1-(4-fluorophenyl)-1-aminopropyl-1,3-dihydroisobenzofuran having the structure:



with an enantiomerically pure acid;

- (b) hydrolyzing a product from (a) using a base;
- (c) methylating a product recovered from (b); and
- (d) recovering escitalopram.

9. (Original) The process of claim 8, wherein an enantiomerically pure acid is a di-benzoyltartaric acid, a di-p-toluoyl tartaric acid, an o-nitrobenzoyl tartaric acid, lactic acid, bisnaphthylphosphoric acid, 10-camphorsulfonic acid, 8-camphorsulfonic acid, malic acid, N-acetyl glutamic acid, or mandelic acid.

10. (Original) The process of claim 8, wherein an enantiomerically pure acid is (-)-di-p-toluoyl tartaric acid.

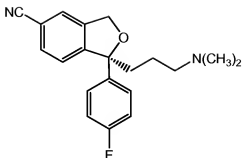
11. (Original) The process of claim 8, wherein a product from (b) is methylated using methyl iodide, dimethyl sulfate or a mixture of formic acid and formaldehyde.

12. (Original) The process of claim 8, wherein a product from (b) is methylated using a mixture of formic acid and formaldehyde.

13. (Original) The process of claim 12, wherein recovered escitalopram contains less than about 0.2 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

14. (Original) The process of claim 12, wherein recovered escitalopram contains less than about 0.01 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

15. (Original) A process for preparing escitalopram having the structure:



comprising the steps of:

- (a) reacting racemic citalopram with an enantiomerically pure acid;
- (b) hydrolyzing a product from (a), using a base; and
- (c) recovering escitalopram.

16. (Original) The process of claim 15, wherein an enantiomerically pure acid is a di-benzoyltartaric acid, a di-p-toluoyl tartaric acid, an o-nitrobenzoyl tartaric acid, lactic acid, bisnaphthylphosphoric acid, 10-camphorsulfonic acid, 8-camphorsulfonic acid, malic acid, N-acetyl glutamic acid, or mandelic acid.

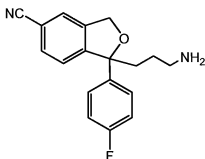
17. (Original) The process of claim 15, wherein an enantiomerically pure acid is (-)-di-p-toluoyl tartaric acid.

18. (Original) The process of claim 15, wherein recovered escitalopram contains less than about 0.2 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

19. (Original) The process of claim 15, wherein recovered escitalopram contains less than about 0.01 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide.

20. (Currently amended) Escitalopram containing less than about 0.01 weight percent of N-{3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl] propyl} formamide[[]], which escitalopram has been prepared by a process comprising methylation of an amine using a mixture of formic acid and formaldehyde.

21. (New) A process for preparing escitalopram oxalate, comprising reacting 5-cyano-1-(4-fluorophenyl)-1-aminopropyl-1,3-dihydroisobenzofuran having the structure:



with an enantiomerically pure acid;

- (b) hydrolyzing a product from (a) using a base;
- (c) methylating a product from (b); and
- (d) reacting a product from (c) with oxalic acid.

22. (New) The process of claim 21, wherein methylating comprises reacting with a mixture of formic acid and formaldehyde.

23. (New) The process of claim 21, wherein methylating comprises reacting with a mixture of formic acid and formaldehyde, wherein an amount of formic acid is in excess of a stoichiometric amount.

24. (New) The process of claim 22, further comprising washing a product from (c) with a solvent in an acidified environment, prior to reacting with oxalic acid.

25. (New) The process of claim 22, further comprising removing an N-[3-[5-cyano-1-(4-fluorophenyl)-1,3-dihydro-2-benzofuran-1-yl]propyl]formamide impurity by washing a product from (d) with a solvent.

26. (New) The process of claim 8, further comprising reacting escitalopram from (d) with oxalic acid to form a salt.